

# Work Order ID 63136

Thursday, October 21, 2010 2:31:41 PM



Page 1

Item ID: D3927-1

Accept



Setup Start



Revision ID:

Item Name: Guard

Stop



Start Date: 10/22/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-10-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3927

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as file D3927-1\_Blank

B10-10-26

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

HAAS

1-Mill as per folio FA & dwg D,

FOLIO REV: B

DWG REV: B

2-Deburr as required

A.A 10/11/02

7

Ø



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		GA	10/11/02	7	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		ank	10/11/04	7	0		
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>96</u>  Memo	0.00  0.00							10/11/04 SP (70)

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Page 3

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Start Date: 10/22/2010 Start Qty: 7.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/05 *[Signature]*  
mr  
10-A-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, October 21, 2010 2:31:41 PM

Page 1

Work Order ID: 63136



Parent Item: D3927-1



Parent Item Name: Guard

Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP RevA: New issue DD verified by:EC  
10.10.21 as per revB DD verified by:

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB1.000X04.0 00		Purchased	No			100	f	45.6000	1.36	10.02105			



B10-10-26

Delrin Bar

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	45.6	
111695	6	
112665	39.6	

$$\begin{aligned} 111695 \times 4 &= 5.44 \\ 112665 \times 3 &= 4.08 \\ &9.52 \end{aligned}$$

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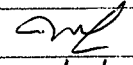
**NOTE:** Date & initial all entries




DART AEROSPACE LTD		Work Order:	63136
Description: GUARD		Part Number:	D3927-1
Inspection Dwg: D3927 Rev: B		Page 1 of 1	

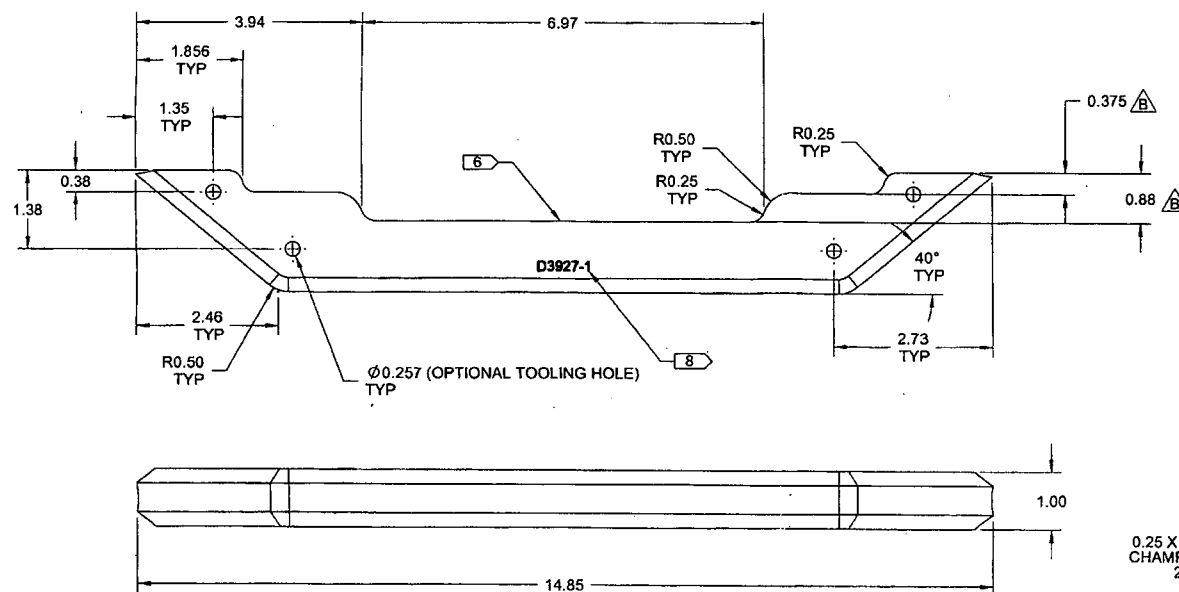
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/- .030	1.370	✓		H-G	31006
0.38	+/- .030	0.375	✓		"	"
1.35	+/- .030	1.347	✓		"	"
1.856	+/- .010	1.856	✓		Vern	GA-01
3.94	+/- .030	3.940	✓		"	"
6.97	+/- .030	6.970	✓		Vern	CNC-02
R 0.50	+/- .030	R0.500	✓		R.6	ref.
R0.25	+/- .030	R0.250	✓		"	"
0.375	+/- .010	0.375	✓		H-G	<del>GA</del> 31006
0.88	+/- .030	0.880	✓		"	"
40°	+/- 1/2°	40°	✓		Angle meter	CNC-03
2.73	+/- .030	2.728	✓		H-G	31006
14.85	+/- .030	14.850	✓		TAPE	GA-12
1.00	+/- .030	1.022	✓		Vern	GA-01
2.13	+/- .030	2.126	✓		H-G	31006
0.25x45°	+/- .030	0.253x45°	✓		Vern	GA-01
R 1.58	+/- .030	R1.580	✓		R.6	ref.

Measured by: MA	Audited by: 	Preliminary Approval:
Date: 10/11/02	Date: 10/11/04	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15



**D3927-1 GUARD**

#63136

**RELEASED**  
2010-09-15

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK  
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.59 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED

DESIGN	REDESIGN: 2.13 WAS 3.25 (C2-1), ADD RELIEF (D3-1), 0.88 WAS 1.13 (D3-1), RMV "NO STEP" TEXT, 16.71 WAS 19.00 (C5-2), 34" WAS 21" (C2-1), ADD OBOUNDS (B2-2)	CP	10.08.22
DRAWN	A	NEW ISSUE	09.03.31
CHECKED	BY	DATE	
MFG. APPR.	DESCRIPTION	BY	DATE
APPROVED			
DE APPR.			
DATE	10.08.22		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3927</b> TITLE <b>GUARD</b> SCALE <b>NTS</b> REV. B SHEET 1 OF 2 COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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